96827 Ship March

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February-07-13	8:22:12 AM	1		90	187 I	<i>/</i> ··			25			Page 1
Item ID: Revision ID:	D3876-5			Accept	*	1900	1040	100)* s	etup Sta	rt *N	S1*
Item Name:	Protector - LI-	H Wall								. Sto	^{pp} *N	S2*
Start Date: Required Date:	2/07/13 : 3/22/13	Start Qty: 12.00 Req'd Qty: 12.00	*12 ⁻ *12 ⁻			Cust Item Customer:					1 4	() /
Reference:												
Approvals:		an: MUS	•				ate:		R	Run Sta Ste	1/1	R1*
	QC:		Date:	SPC (Y/N):		D	ate:				*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	· · · · · · · · · · · · · · · · · · ·	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr										
D3876	RE	V A										
*100 *100*		FLOW WATER JET		0.00			•					4.
Waterjet FLOW CNC Waterj	et	Memo 1-Cut as per Dwg Rev: Prog Rev:_ 2- Deburr if i	<u>/</u>	0.00					/2_			JM13 2-2-
110		QC2- Inspect parts off ma	achine FAI/FAIB	0.00								
QC Quality Control		Мето		0.00					17	<u></u>		JM13-2-2
* 12 0*		QC8- Inspect parts - secon	nd check	0.00					İ٦			
QC Quality Control		Memo		0.00 15) ~				12		<u> </u>	
				لإلاا								

											DQA:	Date:	
NCR: Y	es	/ No				WORK ORDER NON-	COI	NFORM	AANCE / UP	DATE	QA Closed:	Date:	
				-							QA Closed.	Date.	
w lost						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Orde	r: _					Rework	٦		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N						Scrap	┪ ゚		Vachining	Small Fab	Pro	d. Eng. Coor.	Quality
Faitin	··· -					Use-as-is	1		noforming	Finishing	-}	re/Packaging	Other
NCR N	lo.					Work Order Update	1		Large Fab	Composite	1	Supplier	1
1	_								·				
Root		· ,			Descri	iption of work order update		Initial	Act	ion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Cr	nief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data													1
Equip/Tooling										•			
Operator				']		1						
Material													
Setup											1		
Other			ļ		ļ								
Process	Ш]		İ								
Supplier													
Training													
Unapproved									0000				
		· · · · · · · · · · · · · · · · · · ·					AU	LT CATE	GORY	447			
Landir					_	General		Grain			Ovalized		Pressure/Forced
	-	Bending			0/5	Bend	\vdash	4		<u> </u>	Over/Under	toloranco	Temperature/Cure
	-	Centre N	ot Conce	ntric to	^{0/8} -	BOM/Route	\vdash	Hardwa	ire ion Incomplete	 	Part Incorre		Weld
	ш	Cracks	C=:= = -1		-	Broken/Damaged	\vdash	'	ion incomplete/l	Inclear	Part Lost/M	-	Wrong Stock Pulled
	\blacksquare	Crushed/	crimpea		-	Burrs	-	Mainte	•	Officieal	Part Moved	_ <u> </u>	J 51.18 51.55K. 1 direct

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 96827

February-07-13 8:22:12 AM

96827

Item ID: Revision ID: Item Name:	D3876-5 Protector - LI	ł Wall		Accept	*N900	040	100)* s	Setup Star	ולימו
Start Date: Required Date: Reference:	2/07/13 : 3/22/13	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item I Customer:	D:				INIO
Approvals:	Process Pla	nn:	Date:	Tooling: SPC (Y/N):		ate:		F	Run Sta Sto	"NRT"
Sequence ID/ Work Center II 130 *130* Packaging Packaging	D	Operation Description Identify as per dwg & Sto	Ck Location:	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Insp. Number Stamp
140 *140* QC Quality Control		QC21- Final Inspection - Memo	Work Order Release	0.00					13	b/26x)

WORK ORDER NON-CONFORMANCE / UPDATE

DQA:

Date:

NCIN.	CJ	, 110				Work on ben to the					QA Closed:	Date	e:
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	-					Rework Scrap			Skid-tube Machining	Crosstube Small Fab	i	Water Jet	Engineering Quality
NCR N	No	<u> </u>				Use-as-is Work Order Update]	Thern	noforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other
Root					Descri	ption of work order update	lr	nitial	Ac	ction	Sign &		
Cause	- 1	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data		·											
Equip/Tooling												:	
Operator									,				
Material													
Setup													
Other											•		
Process													
Supplier													
Training				:									
Unapproved													
				•		F.	AUL'	T CATE	GORY				
Landi	ng G	Gear				General	_				-	_	
		Bending				Bend	Ш	Grain			Ovalized	Ļ	Pressure/Forced
		Centre No	ot Concei	ntric to	o/s	BOM/Route		Hardwa	ire	<u></u>	Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld
		Crushed/	Crimped			Burrs		instruct	tions Incomplete,	/Unclear	Part Lost/M	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		Part Moved		
		Heat Trea	at			Countersink		Mislabe	eled	L	Positioned V	Vrong	
		Inspectio	n Strip in	Tube		Cut Too Short		Misrea	d		Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes		Offset					
		Torque W	Vaves in I	Extrusio	n 🗍	Drawing		Out of	Calibration				
		Turning S	Sequence	<u>!</u>		Finish		Out of	Sequence				
		Wave/Tw	vist in Tul	be		Folio		Outside	e Dimensions				

Picklist Print

February-07-13 8:22:16 AM

Work Order ID: 96827

96827

Parent Item:

D3876-5

D3876-5

Parent Item Name: Protector - LH Wall

Start Date: 2/07/13

Required Date: 3/22/13

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A 09-01-14 new issue DD verifyed by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	11.6273	12.04	1 52.084 2	•		
*MI FXS 1	25-F60	120_D/	k						**	1/ -			Th 12-2

MI FXS 125-F60029-04
GE PLASTICS LEXAN SHEET

Location Loc Qty Loc Code MAT019 11.6273 11-6273

124654

124654

160

Page 1

JM13-2-22

DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Engineering Crosstube Water Jet Skid-tube Rework Prod. Eng. Coor. Quality Small Fab Machining Part No. Scrap Rec/Store/Packaging Other **Thermoforming** Finishing Use-as-is Supplier Work Order Update Large Fab Composite NCR No. Sign & Description of work order update Action Initial Root Verification QC Inspector Chief Eng Description Date or Non-conformance Cause Date Step Qty Doc/Data Equip/Tooling Operator Material Setup Other **Process** Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Pressure/Forced Ovalized Grain Bend Bending Temperature/Cure BOM/Route Over/Under tolerance Hardware

Wrong Stock Pulled Instructions Incomplete/Unclear Part Lost/Missing Crushed/Crimped Burrs Maintenance Part Moved Contamination Cuffs Positioned Wrong Countersink Mislabeled Heat Treat Power Loss/Surge Other Cut Too Short Misread Inspection Strip in Tube **Drill Holes** Offset Ripples in Bend Out of Calibration Drawing **Torque Waves in Extrusion** Finish Out of Sequence Turning Sequence Folio **Outside Dimensions**

Inspection incomplete

Part Incorrect

Weld

Wave/Twist in Tube

Cracks

Centre Not Concentric to O/S

Broken/Damaged

DART AEROSPACE LTD	Work Order:	96827
		, 00
Description: Protector - LH Wall	Part Number:	D3876-5
Inspection Dwg: D3876 Rev: A		Page 1 of 1

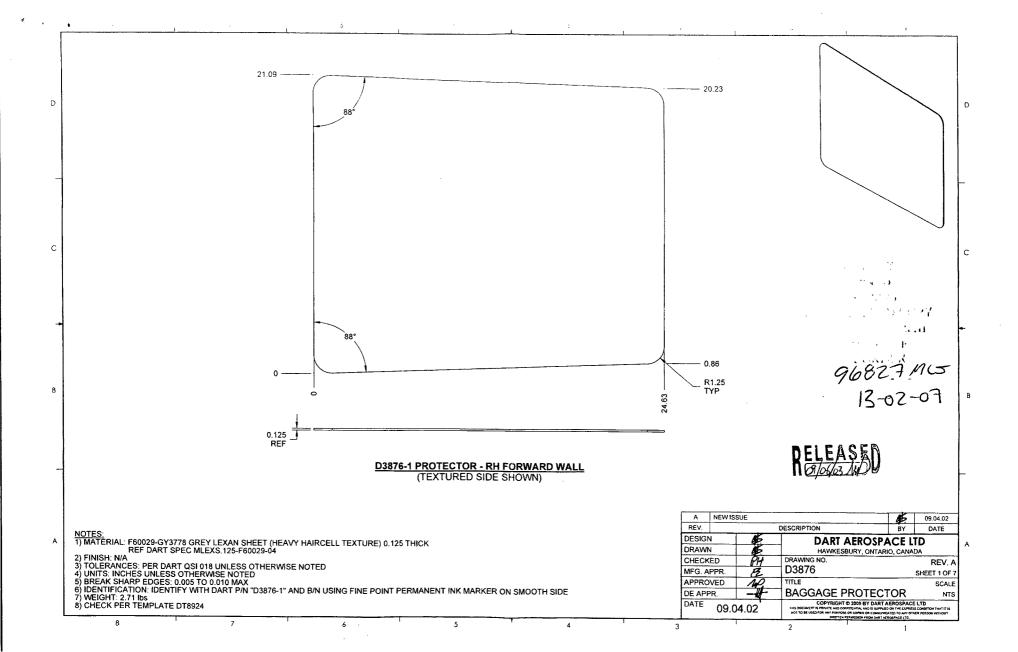
FIRST ARTICLE INSPECTION CHECKLIST

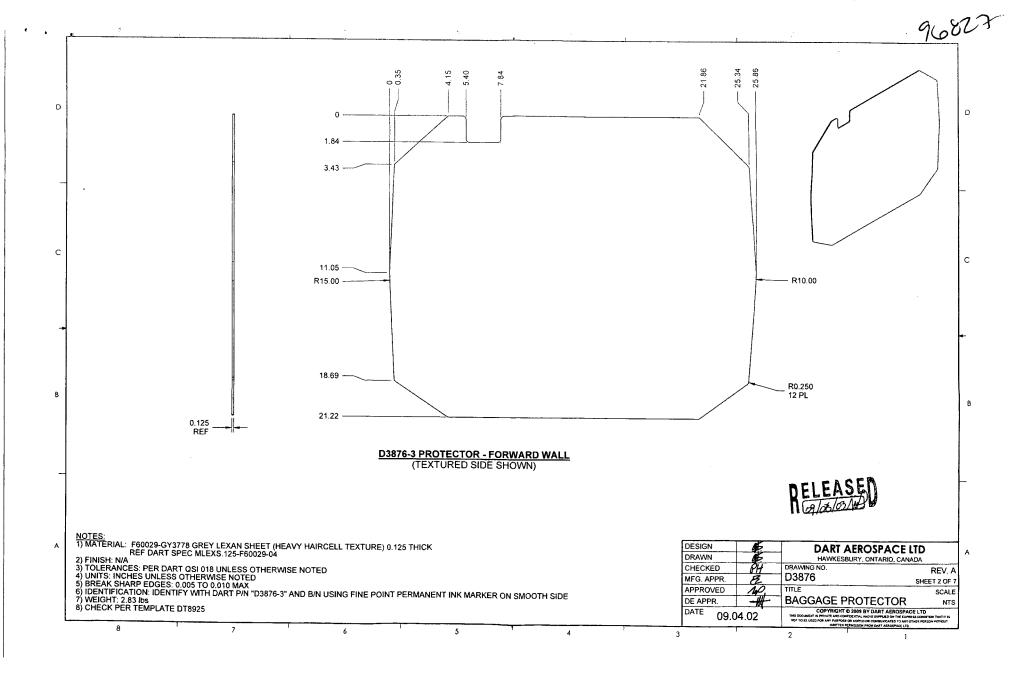
X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
20.68	+/-0.030	20.684	_		T	Jkm06
81.4	+/-0.100	ુ છા.પ્ ^પ	_		+	
0.125	+/-0.010	30.68" BI.4" C.136"	-		V	Jkmoi
-			, , , , , , , , , , , , , , , , , , ,			
				· · · · · · · · · · · · · · · · · · ·		
						·
						·

Measured by:	Jm	Audited by:	13 S	Prototype Ap	proval:	N/A
Date:	12-2-22	Date:	13225		Date:	N/A

Rev	Date	Change	Revis	ed,	by	Approved
Α	09.06.22	New Issue	KJ	9	+-	A





96827 D D 20.68 18.55 С С 2.76 0.125 REF R0.75 2 PL В R2.13 D3876-5 PROTECTOR - LH WALL (TEXTURED SIDE SHOWN) NOTES:
1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04 DESIGN DART AEROSPACE LTD REF DART SPEC MLEXS.125-F60029-04
2) FINISH: NIA
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3876-5" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE
7) WEIGHT: 8.07 Ibs
8) CHECK PER TEMPLATE DT8926 DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D3876 MFG. APPR. SHEET 3 OF 7 APPROVED TITLE BAGGAGE PROTECTOR DE APPR. COPYRIGHT © 2009 BY DART AEROSPACE LTD
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D D 18.24 19.87 0.27 1.63 R2.00 8.50 -2 PL 15.37 -R0.25 8 PL 17.00 0.125 REF D3876-7 PROTECTOR - AFT WALL (TEXTURED SIDE SHOWN) NOTES:
1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04 DESIGN DART AEROSPACE LTD REF DART SPEC MLEXS.125-F60029-04

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3876-7" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE

7) WEIGHT: 1.79 ibs

8) CHECK PER TEMPLATE DT8927 DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D3876 MFG. APPR. SHEET 4 OF 7 APPROVED TITLE SCALE BAGGAGE PROTECTOR DE APPR. NTS

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